

Work Order ID 69672

Monday, May 16, 2011 9:27:26 AM

Page 1



Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 5/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/8/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals: Process Plan: *CY*Date: *11/05/16*

Tooling:

Date:

QC: *A*

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Document Control

Memo

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Sub 666

110

0.00



Large Fab

Large Fab

Large Fab

Memo

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

M114703
M115928

3-Grind End Plate flush

11.05.19 10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

*NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

x 10 0 8EN/05/19

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/05/19



140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10LHX M/11/05/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

*11.05.28**10**Ø*

QC

Memo

0.00

Quality Control

180

Large Fab

0.00

*10**Ø*

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R □ Aluminum Rod □ *M114703*

6-Grind End Plate flush

7-Install last rivet as per Dwg.

11.05.30
A.E. 11.05.30

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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[illegible]

Page 4

Accept

Abstract

Setup Start

Abstract

Stop

[illegible]

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Cust Item ID:

...the ...

Customer:

Run Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

**Insp.
Stamp**

0.00

[REDACTED]

0.00

QC

Memo

Quality Control

0,00

0.00

[illegible]

0.00

QC

Memo

Quality Control

0.00

0.00

[REDACTED]

0.00

HandFinish

Memo

Hand Finishing

0.00

10x ~~Ø~~ M-L 11/05/31
LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00



Powdercoat

Powder Coating

Memo

START TIME: 1:00

OVEN TEMPERATURE: 320 °F

FINISH TIME: 1:30

10 ~~0~~ M-11/05/31
LHx

230 Wing Walk as per dwg QSI005 4.4 Batch 0.00



HandFinish

Hand Finishing

Memo

M 117315.

10 ~~0~~ 11-5-31.

240 QC3- Inspect Part Finish 0.00



QC

Quality Control

Memo

10 H1 ~~0~~ 11/05/31

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 Packaging Packaging	Pick Kit Memo	0.00 0.00						11/6/25	(10)
260 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		8 u106666				HD LH	
270 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD350-591-311 Location: _____	0.00 0.00						11/6/7	(100) \$

ReoB

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/8 JF

11-06-7 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Monday, May 16, 2011 9:27:23 AM

Page 1

Work Order ID: 69672

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH



Start Date: 5/16/2011

Required Date: 6/8/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3272-1 JLM
 IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
 IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 Step		Manufactured	No			110	Each	20.0000	1	10		11.05.16	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		20							
				67709		10			10				
				69294		10							
D3067-1 End Plate		Manufactured	No			110	Each	155.0000	1	10		11.05.16	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		5							
				67582		5			3				
				WA016		150							
				68214		150			7				
D3219-1 Plate		Manufactured	No			110	Each	204.0000	2	20		11.05.16	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		84							
				68202		84			20				
				WA017		120							
				68338		120							

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 5/16/2011

Required Date: 6/8/2011

Start Qty: 10.00

Required Qty: 10.00

D3066-1 Manufactured No

180 Each

88.0000

2

20



Spacer



11.05.30

Location

Loc Qty

Loc Code

WA

88

68337

88

20

MS20600-AD4W4

Purchased

No

180

Each

1,808.000

16

160



Rivets



11.05.30

Location

Loc Qty

Loc Code

ST321

1803

116188

603

117364

1000

117601

200

160

WA018

5

116712

5

D3065-041

Manufactured

No

180

Each

38.0000

1

10



Step Leg Assembly Hi



11.05.30

Location

Loc Qty

Loc Code

WA

38

66149

0

67503

38

10

D3067-1

Manufactured

No

180

Each

155.0000

1

10



End Plate



11.05.30

Location

Loc Qty

Loc Code

WA

5

67582

5

WA016

150

68214

150

10

Monday, May 16, 2011 9:27:23 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Start Date: 5/16/2011

Required Date: 6/8/2011

Start Qty: 10.00

Required Qty: 10.00

AN3-35A
Bolt

Purchased No

250 Each

131.0000

2 20



[Handwritten signature]

Location

Loc Qty

Loc Code

ST353

131

117313

31

117441

50

117619

50

20

D3235-1

Manufactured No

250 Each

123.0000

2 20



[Handwritten signature]

Location

Loc Qty

Loc Code

ST471

123

67831

23

68292

100

20

D3278-041

Manufactured No

250 Each

58.0000

1 10



[Handwritten signature]

Location

Loc Qty

Loc Code

ST471

58

67584

18

68957

40

10

AN960JD416

NAS1149D0463J

Purchased No

250 Each

0.0000

16 160



M117291 *[Handwritten signature]*

Washer

AN960JD516

NAS1149D0563J

Purchased No

250 Each

0.0000

4 40



M117291 11/6/12 *[Handwritten signature]*

Washer

W/O:		WORK ORDER CHANGES					
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Start Date: 5/16/2011

Required Date: 6/8/2011

Start Qty: 10.00

Required Qty: 10.00

AN5-36A Purchased No 250 Each 103.0000 2 20
 Bolt
Handwritten: S NO

Location Loc Qty Loc Code

ST341 103
 117366 103

D2618 Manufactured No 250 Each 90.0000 2 20
 Bushing
Handwritten: S NO

Location Loc Qty Loc Code

ST019 90
 68249 90

D2230-3 Manufactured No 250 Each 212.0000 4 40
 Lug
Handwritten: S NO

Location Loc Qty Loc Code

Return 2010 4
 62927 2
 63544 2
 ST476 208
 65050 48
 68246 160

D2856-400 Manufactured No 250 f 179.2696 1.2
 Abrasion Strip
Handwritten: S NO

Location Loc Qty Loc Code

ST403 178.6
 68076 178.6
 ST409 0.6696
 63735 0.6696

*** cut (2) at 7.20" (D2856-400-720) ***

Handwritten: measured 5/16/11

Monday, May 16, 2011 9:27:23 AM

Shop Packet Print

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 5/16/2011

Required Date: 6/8/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

250

Each

2,247.000

2

20



Nut

Location

Loc Qty

Loc Code

ST300

2247

116391

11

116540

270

116549

766

117441

800

117601

400

AN4-13A

Purchased

No

250

Each

245.0000

8

80



Bolt

Location

Loc Qty

Loc Code

ST357

245

117628

245

MS21042L5

Purchased

No

250

Each

1,275.000

2

20



Nut

Location

Loc Qty

Loc Code

ST300

1275

116105

315

116548

260

117441

500

117591

100

117611

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 16, 2011 9:27:24 AM

Page 6

Work Order ID: 69672



Parent Item: D350-591-311



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 5/16/2011

Required Date: 6/8/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

4,957.000

8

80



Nut

Location

Loc Qty

Loc Code

ST300

4957

114718

2

116823

1155

117441

3000

117601

800

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

40



Washer

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *H*

△
B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

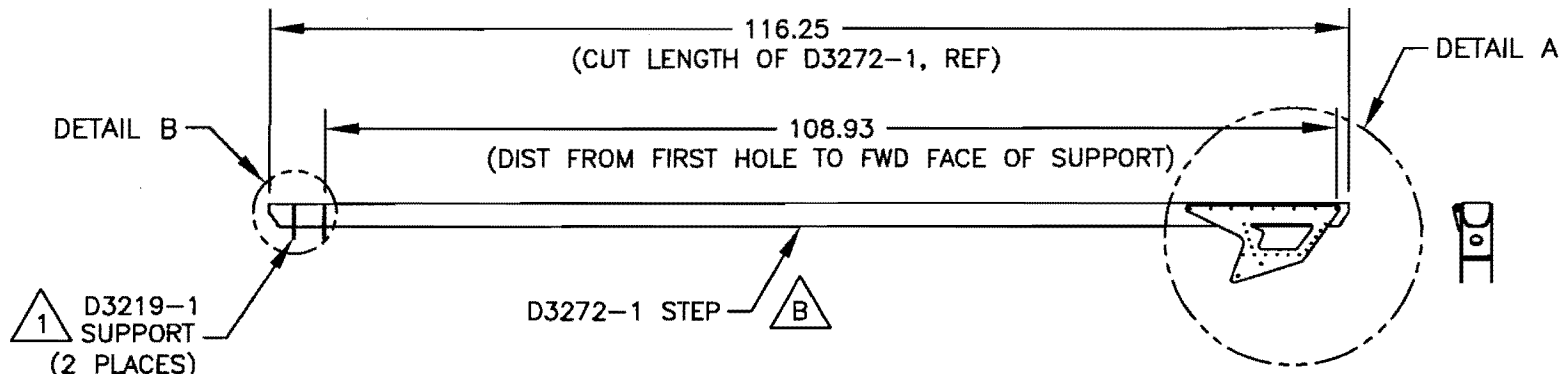
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

CL 11105114

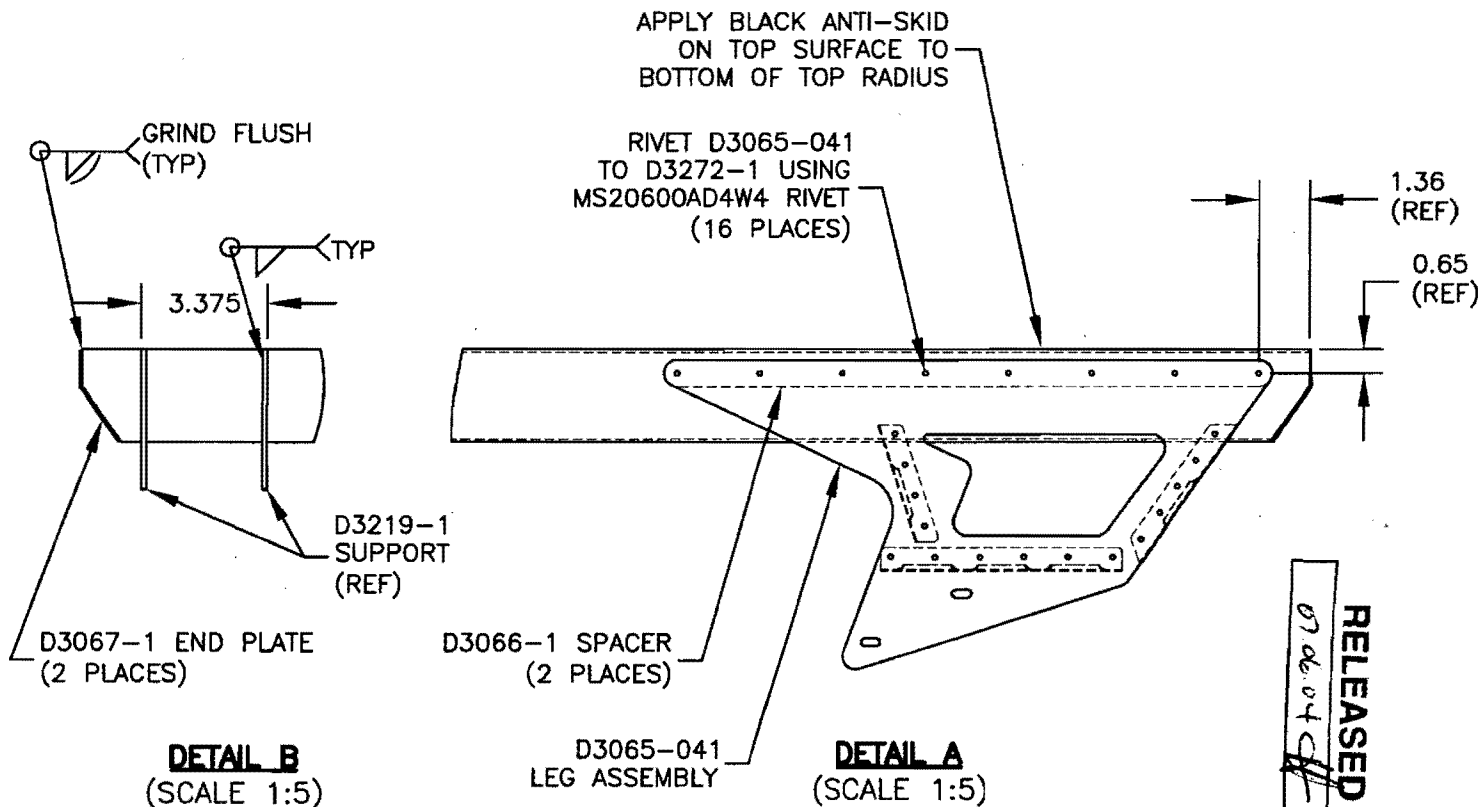
W10: 69672

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D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.06.04

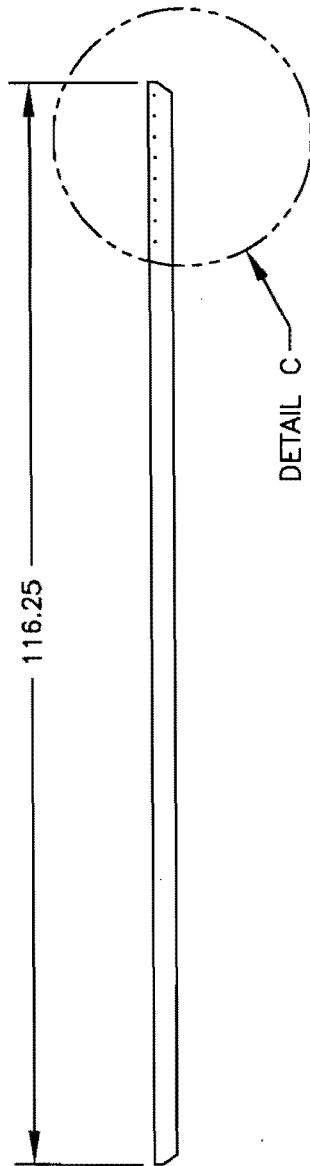
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CHECKED [Signature]	APPROVED [Signature]	REV. B
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE 1:20



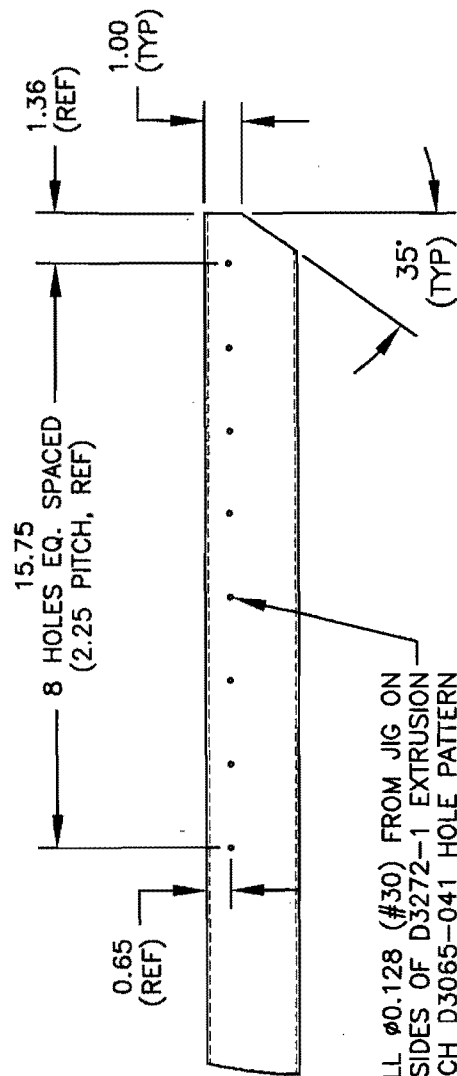
DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

07.06.04 *[Signature]*



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						1		D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

